ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

MPP

Date:	13.06.06	Job No.:	ENG4108JUNE	ADR Yes/No:	Y	ADR Date:	13.06.06
Product No.:	D206-642			Created By:	DW	Approved By:	MP
Product Name:	SKIDTUBE ASSEMBLY			Checked By:		ECN #:	13- ~~367~~ 634

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	Y	NF	
Production Manager / Coord.	Y	LL/MF	
Purchasing Coord.	N	CL	
Production Engineering Coord.	Y	DD/JLM	
Production Engineering Coord.	N	DL	
Customer Order Processing	N	RM/CA	

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
DQA / QA Coord.	Y	PS	
QC Coordinator	Y	ED	
Customer Support	Y	SW/LM	13.09.05
Customer Technical Support	Y	MB/DS	13.09.05
Marketing	~~Y~~ N	HM	
SALES SUPPORT MANAGER	N	NM	

Reason for Change:
DUE TO THE POROSITY OF POWDER COATING, CORROSION IS AN ISSUE ON THE FLOAT TUBES.

Documents Affected:
REVISE D3274 TO REV. E, REVISE D3288 TO REV. H, REVISE D4362 TO REV. B
REVISE MDL-D206-642 TO REV. AE

PAPERWORK UPDATE ☐ **PARTS MUST COMPLY** ☐ **PREVIOUS PARTS SATISFACTORY** [X]

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	Y	DW		13.09.05 DW
6	Update Product Compatability Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		13.09.05
11	Update Product Specification Files	N			
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		13.09.04
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Create/Update Parts / STC Database	N			
17	Update / Verify ARC Database	N			
18	Create / Update Change Record Form / Item Card Database	Y	KJ	SEE BELOW	
19	Create / Update PPP's	Y	KJ		
20	Red Decals required?	Y	KJ		
21	Update Document Control Database / Laminated Dwgs	N			
22	Update Grey Project / Electronic Binder PDF Files	Y	KJ		13.09.04
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		13.09.04
24	Manufacturing Licensing Agreement Update	N			

Description / Action:
REF. PAR13-256, THERE ARE CONCERNS REGARDING THE FINISHING ON THE D206-642-511/-512.
WE NEED TO MOVE FORWARD WITH A NEW PAINT PROCESS ON THE FLOAT TUBES.

D206-642-515/-516/-517/-518/-551/-555 AT CHG 002, D206-642-545 AT CHG 003, D206-642-513/-514/-541/-641 AT CHG 004
D206-642-511/-512/-611/-612/-613/-614 AT CHG 005

PARTS IN STOCK ACCEPTABLE

N/A
w 13.09.17
5 gallons ARC stk

ECN Verified & Complete: _____ Date: _____

4.2 Prime, Paint

4.2.1 Prime

4.2.1.1 Prepare all surfaces to be primed using Dupont *4105S Wash' n' Wipe Degreaser.* Be sure not to leave any residue on the parts by passing a good quality tack rag over surface.

4.2.1.2 Mix primer / paint as per manufacturer's instructions and allow to activate.

4.2.1.3 Prepare 2-part epoxy primer in accordance with manufacturer's instructions.

4.2.1.3.1 Acceptable primers for composite coatings are:

Tempo 4500-P-40 primer (consists of 4500-P-40 base and 4500-C-40 catalyst)
Dupont 2K urethane Primer – LE3404S
Actuator/Reducer – LE1175S

4.2.1.3.2 Acceptable primers for aluminum and steel are:

Any MIL-P-23377 primer
Any MIL-P-85582 primer
Tempo 4500-P-23 primer (consists of 4500PB-23 base and 4500-C-23 catalyst)
Tempo Grey 4500PB-40B
Sherwin Williams (CM0483928)

4.2.1.3.3 Acceptable primers for float skidtubes are:

PRC Desoto Primer 515X349 (Boeing Spec BMS 10-79 Type III Class A Grade A)

4.2.1.4 Priming crosstubes interior: Pour primer into tube as necessary. Submerge; saturate the sponge with primer and drag through the tube back and forth until complete coverage is achieved. Empty the tube of remaining primer, let tube sit upright for 20 minutes to drip dry to ensure no excessive build up in the tube occurs. When applying the primer to the parts surface, use light even coats until the part is homogenous in colour as per the manufacturer's instructions.

4.2.1.5 Preferred procedure is to prime crosstubes with Tempo 4500-P-23. Allow the Tempo 4500-P-23 to dry from 4 hours minimum to 6 hours maximum before applying the topcoat. This is to be done under normal conditions of 77°F and 50% relative humidity as per manufacturer's instructions.

NOTE: If the Tempo 4500-P-23 primer dry time exceeds 7 hours before applying the topcoat, let the primer cure for 16-18 hours and sand lightly using a maximum 320 grit sanding paper.